

Date: Thursday, 11/01/2007 2:32:43 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET		
Job Number	: 30246					
Estimate Number	: 12633					
P.O. Number	: N/A		Part Number	: D35383		
This Issue	: 11/01/2007 S.O. No. : N/A		Drawing Number	: D3538 REV.A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: N/A		Material	: N/A		
Written By	: W		Due Date	: 18/01/2007 Qty: 60 Um: Each		
Checked & Approved By						
Comment	: Est Rev:A New Issue 07-01-10 EC					
Additional Product						
Job Number:						
Seq. #:	Machine Or Operation:	Description :				
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"				
						
Comment: Qty.: 0.2205 f(s)/Unit Total : 13.2300 f(s) 6061_T6 Bar 1.250" x 1.250" Batch: M18742 X12 S J.F. 07/02/02						
2.0	BAND SAW	BAND SAW				
						
Comment: BAND SAW Cut blanks 1.760" long J.F. 07/02/02						
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1				
						
Comment: 1-Machine as per Folio FA668 and Dwg D3538 2-Deburr J.F. 07/02/02						
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE				
						
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 07/02/02						
5.0	QC8	SECOND CHECK				
						
Comment: SECOND CHECK J.F. 07/02/02 (6)						

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/02/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/01/2007 2:32:43 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 30246

Part Number: D35383

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML/YL

07-02-06 (60)

7.0 POWDER COATING POWDER COATING



m103141

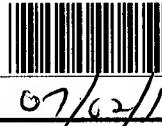
Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML/YL

07/02/12 (60)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL/YL 07/02/12 (60)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PL/YL 07/02/12 (60)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PL/YL 07/02/13 (60)

Job Completion



PL/YL 07/02/12 (60)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

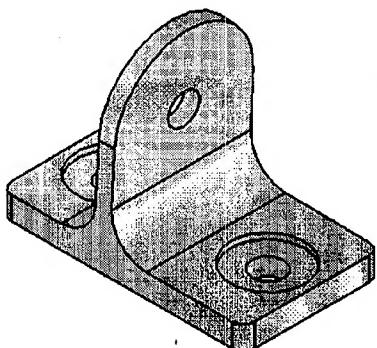
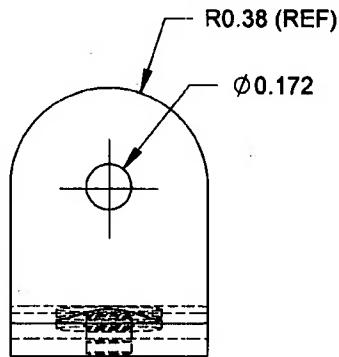
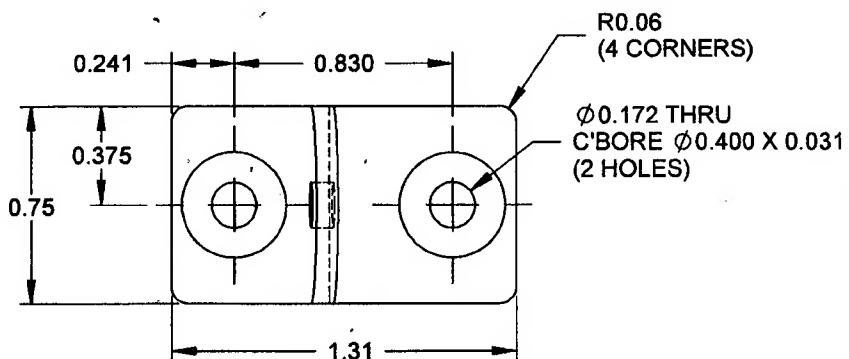
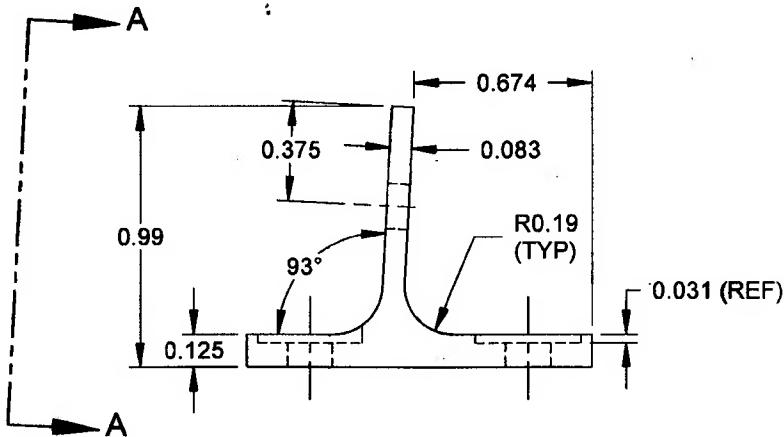
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3538	REV. A	SHEET 1 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1	
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE		

**RELEASED**
(06.10.13)
#**AUXILIARY VIEW A****D3538-1 HINGE BRACKET****NOTES:**

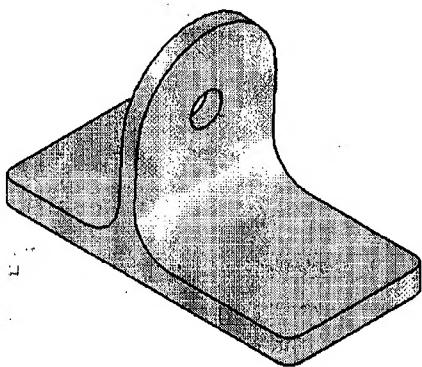
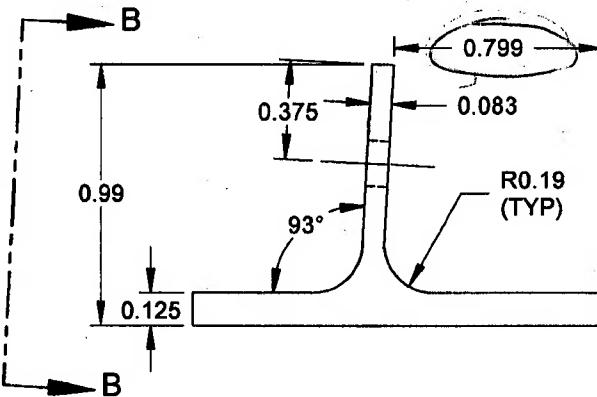
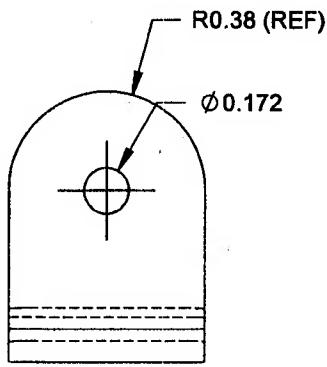
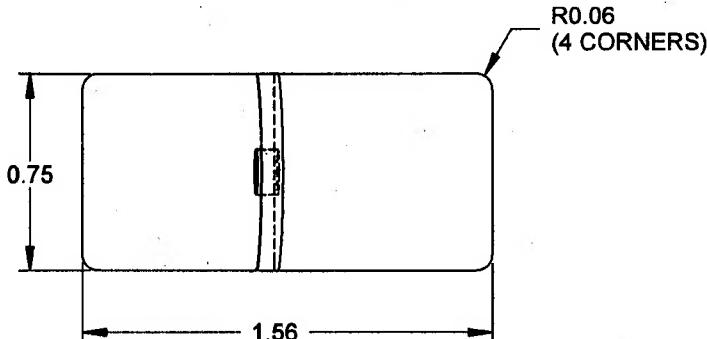
- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3538
DATE 06.10.13	TITLE HINGE BRACKET	REV. A SHEET 2 OF 2 SCALE 1:1

**RELEASED**
06-10-13 AD**AUXILIARY VIEW B****D3538-3 HINGE BRACKET***WJ 30/2/16***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD	Work Order:	30246
Description:	Part Number:	3538-3
Inspection Dwg: , Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	J.F.	Audited by:	S.F.	Prototype Approval:	
Date:	07/02/01	Date:	07/02/04	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	